

File # 5/25/2007 8:37:41 AM
K. Johnston

Process Sheet

Split
8B 07/06/05
Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32661-3
 Estimate Number : 12811
 Proj. Number :
 Job Issue : 5/25/2007 S.O. No. :
 Last Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 32003
 Written By :
 Checked & Approved By :
 Department : Est Rev/A New Issue 07-03.26 ec

Drawing Name : BRACKET
 Part Number : D35921
 Drawing Number : D3592 REV A
 Project Number : N/A
 Drawing Revision : REV A
 Material :
 Due Date : 6/10/2007
 Qty: 125 Um: Each

UNDER)

07-06-04
OK 107-06-04

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description:
1.0	M6061-T6S125	6061-T6 .125 Sheet
		Comment: Qty: 0.1460 sf(s)/Unit Total: 17.5140 sf(s) 6061-T6 .125 Sheet Batch: M104366 ml 0705 30 M104366 ml 0706 04 ***Grain must be Along 4.63"
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3592 Dwg Rev: AA ml 0706 04 Prog Rev: AA ml 0705 30
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		Form as per Dwg D3592 using DT8949



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Process Sheet

in: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number:



seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/08 (24)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

POSITIVE RECALL

Identify and Stock
Location: WHEFFECTIVE 07.08.08 AUTH uRELEASED 07.08.08 DATE 19

8.0

QC21

FINAL INSPECTION/W/O RELEASE



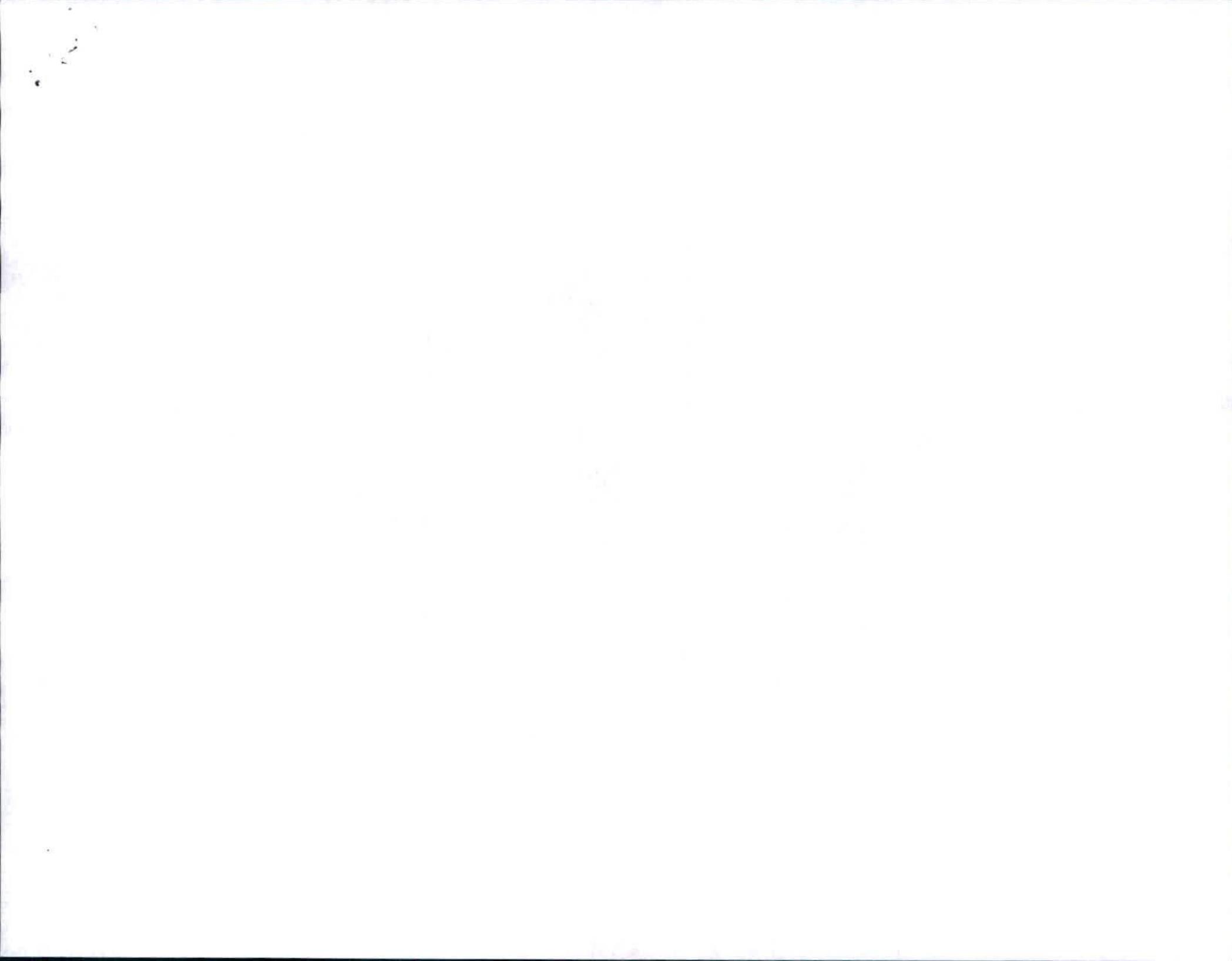
Comment: FINAL INSPECTION/W/O RELEASE

En 07.08.16.

Completion:

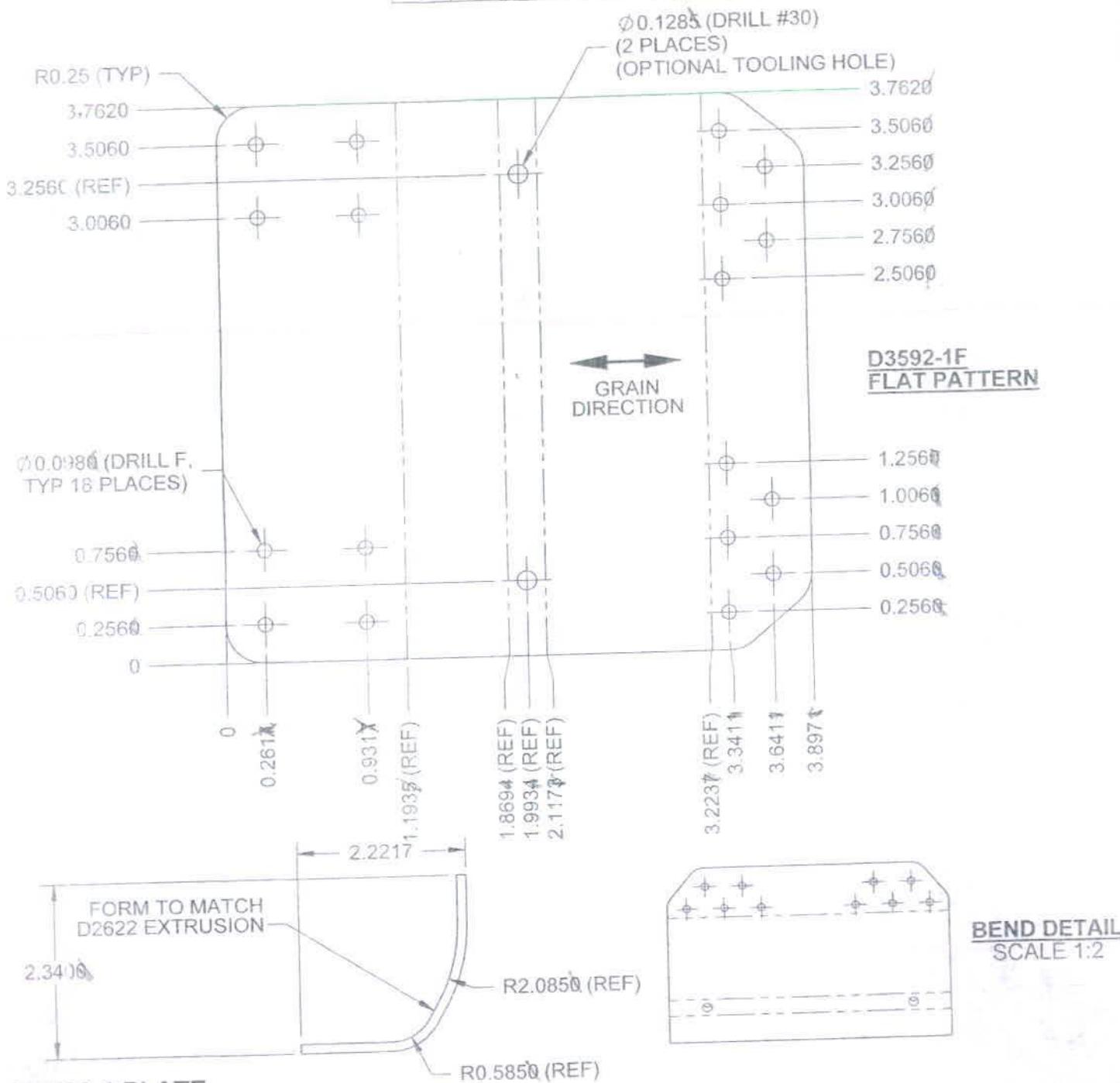


(26/08/15)



EMERGENCY ISSUE
9 07.06.14

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	07.01.15	DRAWING NO.	R.B. REV.A SHEET 1 OF 1
A	07.01.15	TITLE	SCALE
B	07.05.31	PLATE	11



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX



AEROSPACE LTD

Work Order: 32661

Description: Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.128$	+0.005 -0.001	0.129	✓		VERN	
B $\phi 0.098$	+0.004 -0.001	0.099	✓		VERN	
C 0.506	+/-0.010	0.510	✓		VERN	
D 0.256	+/-0.010	0.260	✓		VERN	
E 0.756	+/-0.010	0.760	✓		VERN	
F 3.256	+/-0.010	3.260	✓		VERN	
G 0.261	+/-0.010	0.265	✓		VERN	
H 1.993	+/-0.010	1.995	✓		VERN	
I 3.341	+/-0.010	3.346	✓		VERN	
J 3.641	+/-0.010	3.645	✓		VERN	
K 3.897	+/-0.010	3.902	✓		VERN	
L 3.762	+/-0.010	3.766	✓		VERN	
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: M. M.
Date: 07/06/04

Audited by: M.S.
Date: 07/06/04

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



AEROSPACE LTD

Work Order: 32661

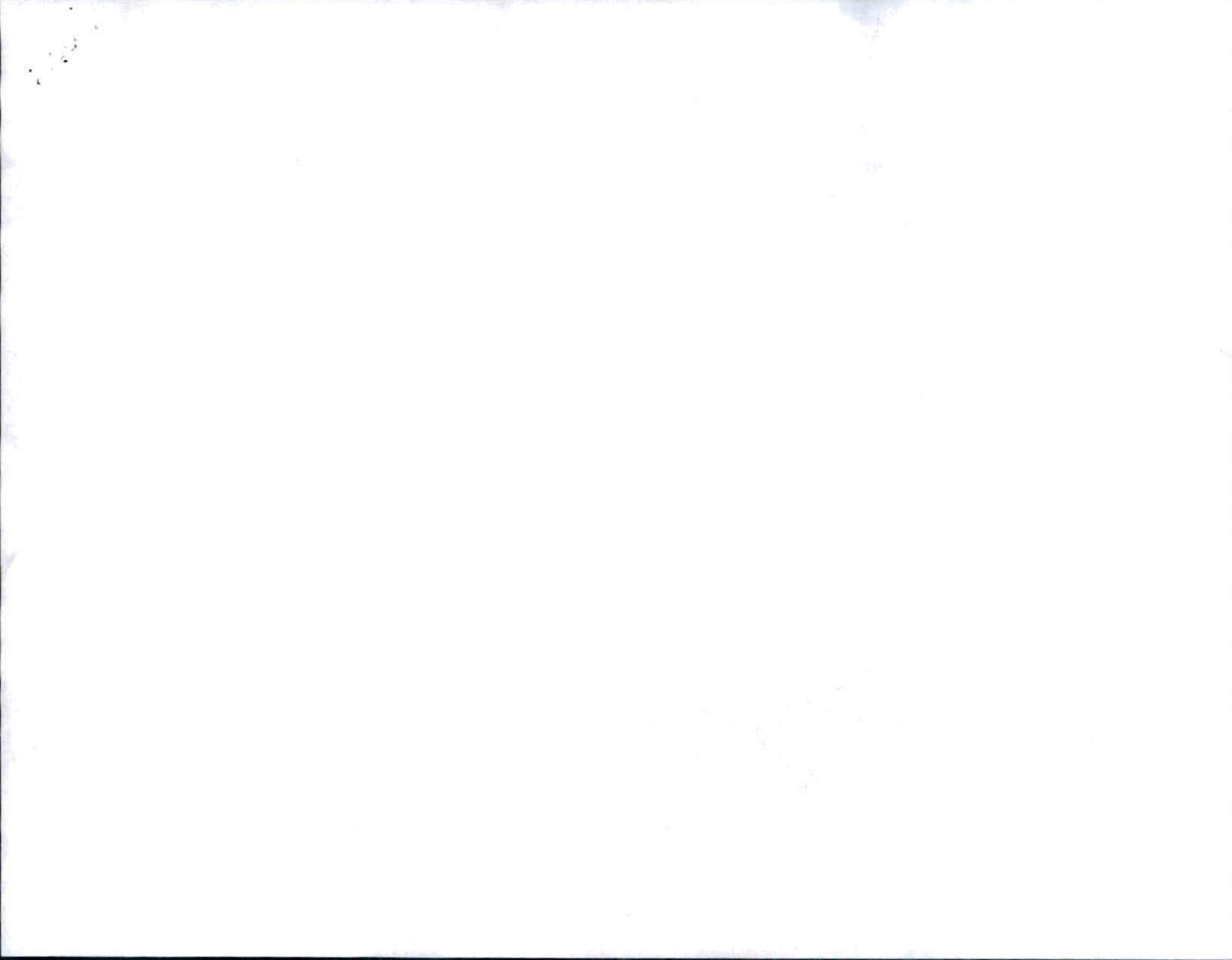
Brisket

Part Number: D3592-1

3. D3592 20 . H

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype



W/O:

WORK ORDER CHANGES

PROCEDURE CHANGE

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/05	2	REPROGRAM TO REL.5 TO ADD TOOLING HOLES. SIZE ATTACHED AS EMAIL FOR OK ON TOOLING HOLES				<i>GP</i> <i>P.R.</i> <i>07/06/05</i> <i>07/06/05</i>	
07/06/05	5	Split w/o	8K	07/06/05	85	<i>J</i>	<i>J</i>
07/06/05	5	Split w/o	SP	07/06/12	42	<i>07/06/12</i>	<i>07/06/12</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: IT Date: 07/06/12

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/04	2.0	125 parts scrup. Parts needed extra holes for the bending tool.	<i>GP</i> 07/06/04 P.R. 05/04/04	SCRUP parts, and replace to Rev. B, under Preliminary Issue. See E-mail	<i>ML</i> 01/06/04 07/06/03	<i>J</i>	<i>GP</i> 07/06/04 P.R. 05/04/04	<i>J</i>
				SCRUP: destroy parts	<i>SP</i> 07/06/04 07/06/04			

NOTE: Date & initial all entries

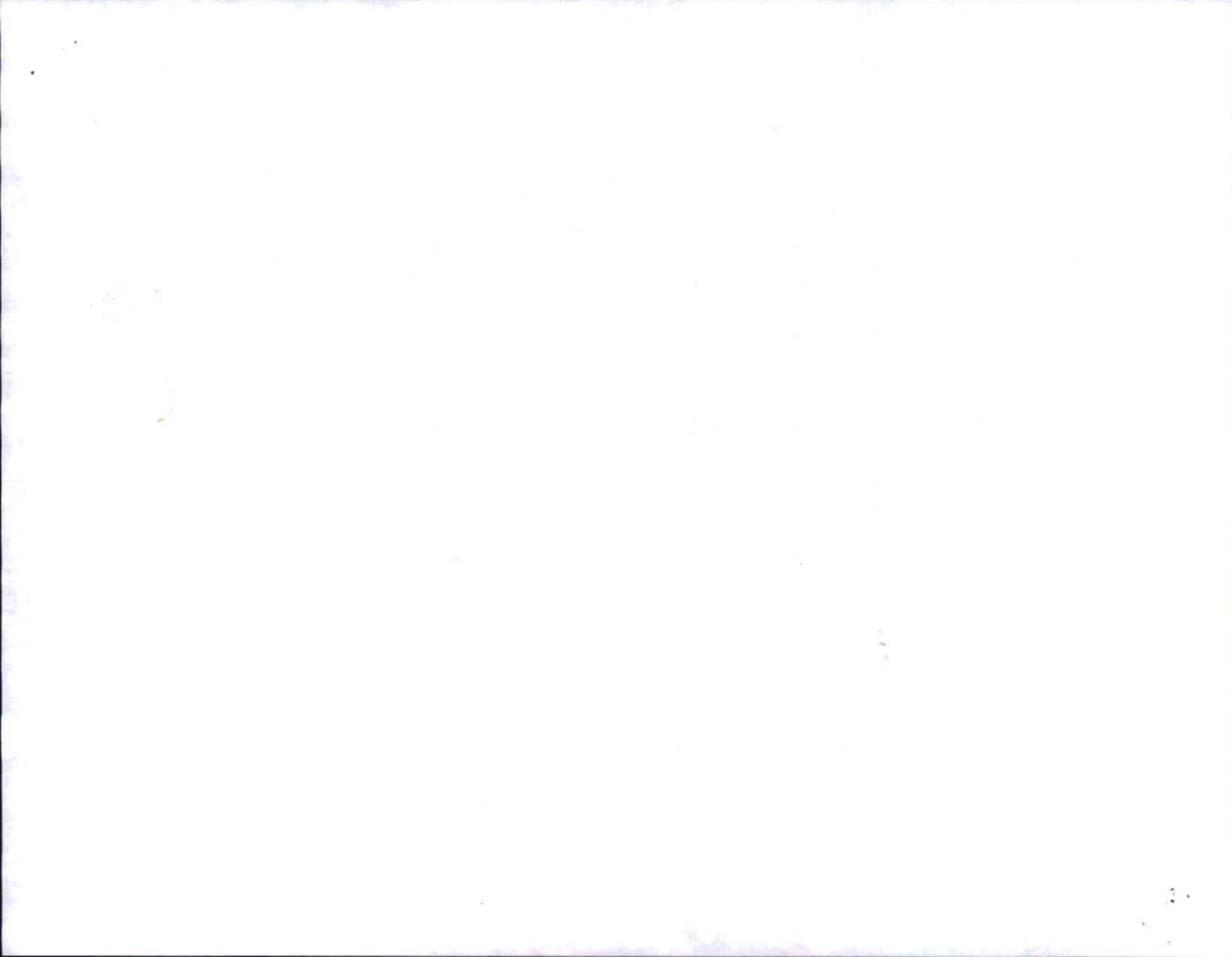
2
1947

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/08	5	Split u/o			SB	07/08/08	29		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

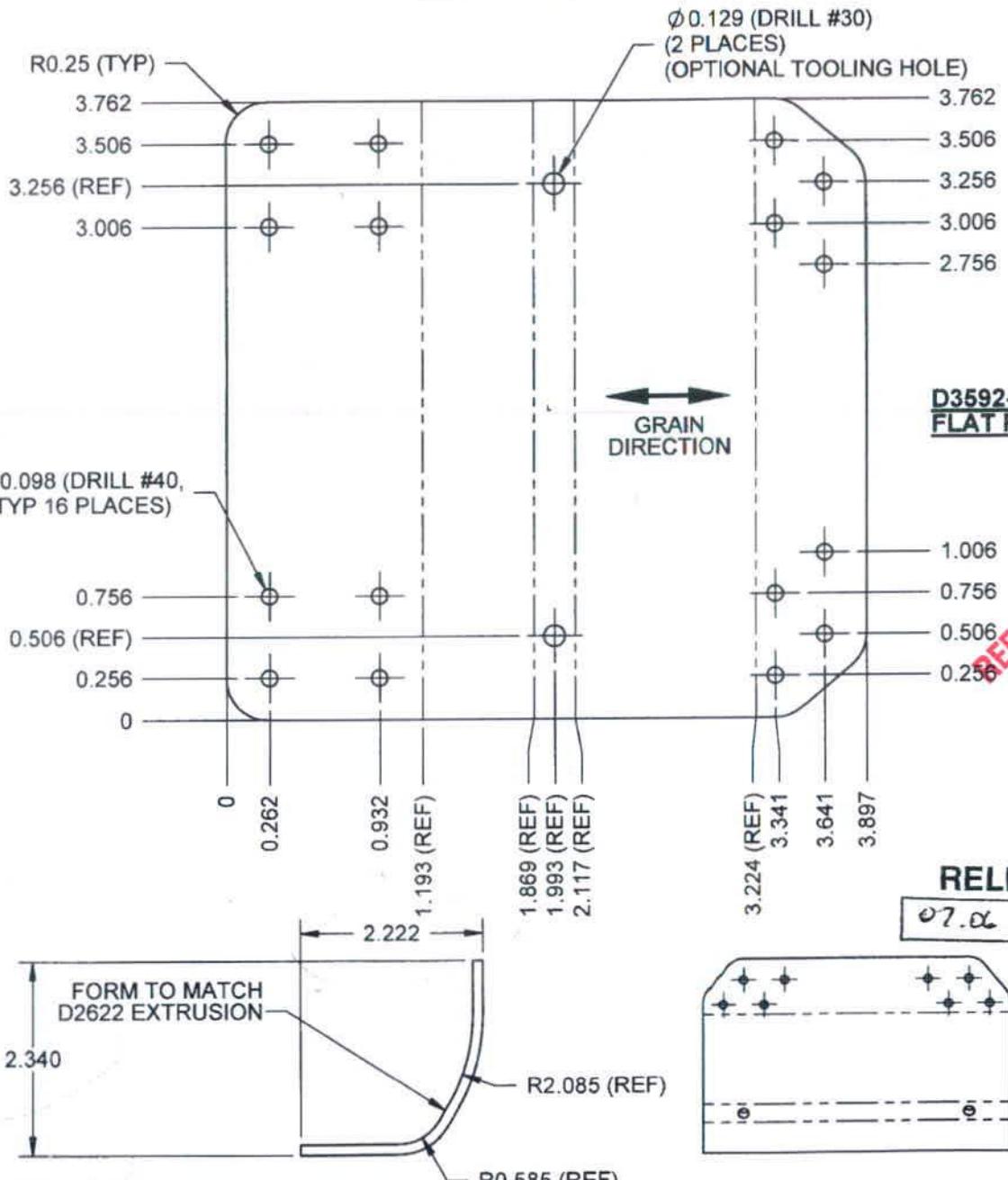
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

DESIGN <i>QP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>QP</i>	APPROVED <i>TH</i>	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**D3592-1 PLATE**

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REF ID: A6512